

# Work Order ID 86342

June-27-12 3:19:41 PM

\*86342\*

Page 1

Item ID: D2435

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Bearpaw, 206

Stop \*NS2\*

Start Date: 27/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2435    | Rev E1       |

|     |  |      |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|
| 120 |  | 0.00 |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|

\*120\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

UHMW 1"

12-7-8

130

0.00

\*130\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435  
3-Deburr

PO 12/07/14

12-07-13

140

QC2- Inspect parts off machine FAI/FAIB

0.00

\*140\*

QC

Memo

0.00

Quality Control

PO 12/07/14

12-07-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 86342

June-27-12 3:19:41 PM

**\*86342\***

Page 2

Item ID: D2435

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw, 206

Start Date: 27/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*OK 12/07/16*

*10*

*10*

151

Identify as per dwg & Stock Location:

0.00

**\*151\***

Packaging

Memo

*111 87886 6x*

0.00

Packaging

*111 87885 4x*

*12/17/17 (10)*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/17/20*

*MLJ 12/07/17*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

June-27-12 3:19:44 PM

Page 1

Work Order ID: 86342

**\*86342\***

Parent Item: D2435

**\*D2435\***

Parent Item Name: Bearpaw, 206

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10                        |                        | Purchased     | No          |                     |                  | 120             | sf                 | 72.0100        | 3.2         | 32           |               |                |        |

**\*MUHMWB10\***

UHMW 1" Black

\*\*

B12-7-5

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT018          | 48.9           |                 |
| 120972          | 1              |                 |
| 121346          | 27.1           |                 |
| 121954          | 20.8           |                 |
| MAT019          | 1.5            |                 |
| 118814          | 1.5            |                 |
| ST052           | 21.60999474    |                 |
| 121277          | 12.8           |                 |
| 121278          | 8.80999474     |                 |

122286

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                               |  |              |       |
|-------------------------------|--|--------------|-------|
| DART AEROSPACE LTD            |  | Work Order:  | 86342 |
| Description: Bearpaw          |  | Part Number: | D2435 |
| Inspection Dwg: D2435 Rev: E1 |  | Page 1 of 1  |       |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance     | Actual Dimension      | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|-----------------------|--------|--------|----------------------|----------|
| A                | 0.063 x 45°       | +0.030/-0.010 | .072                  | ✓      |        | vern                 | RT-4     |
| B                | 5.500             | +/-0.030      | 5.504                 | ✓      |        | "                    |          |
| C                | 0.200             | +/-0.030      | <del>2.000</del> 1.91 | ✓      |        | depth gauge          | RT-06    |
| D                | R0.250            | +/-0.030      | .250                  | ✓      |        | rad gauge            |          |
| E                | 0.250             | +/-0.010      | .248                  | ✓      |        | vern                 | RT-4     |
| F                | 0.625             | +/-0.030      | .630                  | ✓      |        | "                    |          |
| G                | 0.25 x 45°        | +/-0.030      | .252                  | ✓      |        | "                    |          |
| H                | 0.375             | +/-0.010      | .389                  | ✓      |        | "                    |          |
| I                | 19.000            | +/-0.030      | 19.000                | ✓      |        | Tape                 | RT-10    |
| J                | 0.950             | +0.030/-0.010 | .954                  | ✓      |        | vern                 | RT-4     |
| K                | Ø0.260            | +0.005/-0.000 | .260                  | ✓      |        |                      |          |
| L                | Ø0.930            | +/-0.030      | .931                  | ✓      |        | mic                  | RT-001   |
| M                | 0.30              | +0.030/-0.000 | .311                  | ✓      |        | depth gauge          | RT-06    |
| N                | 0.375             | +/-0.030      | .382                  | ✓      |        | vern                 | RT-4     |
| O                | 7.375             | +/-0.030      | 7.375                 | ✓      |        | Tape                 | RT-10    |
| P                | 4.250             | +/-0.010      | 4.257                 | ✓      |        | vern                 | RT-4     |
| Q                | 2.000             | +/-0.030      | 2.004                 | ✓      |        | "                    |          |
| R                | 9.000             | +/-0.010      | 9.000                 | ✓      |        | Tape                 | RT-10    |
| S                | 15.750            | +/-0.030      | 15.750                | ✓      |        | "                    |          |
|                  |                   |               |                       |        |        |                      |          |
|                  |                   |               |                       |        |        |                      |          |
|                  |                   |               |                       |        |        |                      |          |
|                  |                   |               |                       |        |        |                      |          |
|                  |                   |               |                       |        |        |                      |          |

|                        |                       |                     |     |
|------------------------|-----------------------|---------------------|-----|
| Measured by: <u>RT</u> | Audited by: <u>OK</u> | Prototype Approval: | N/A |
| Date: <u>12-07-13</u>  | Date: <u>12/07/16</u> | Date:               |     |

| Rev | Date     | Change               | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A   | 03.09.22 | New Issue P/O K10007 | KJ/RF      |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





RELEASED  
98.06.17 KE

| DESIGN   | DRAWN BY | DART AEROSPACE LTD          |
|----------|----------|-----------------------------|
| KE       | KE       | HAMKESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED | DRAWING NO.                 |
| KE       | KE       | D2435                       |
| DATE     | TITLE    | REV. E                      |
| 98.05.19 | BEARPAW  | SHEET 1 OF 2                |
|          |          | SCALE                       |
|          |          | 1:5                         |

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86342 MLW

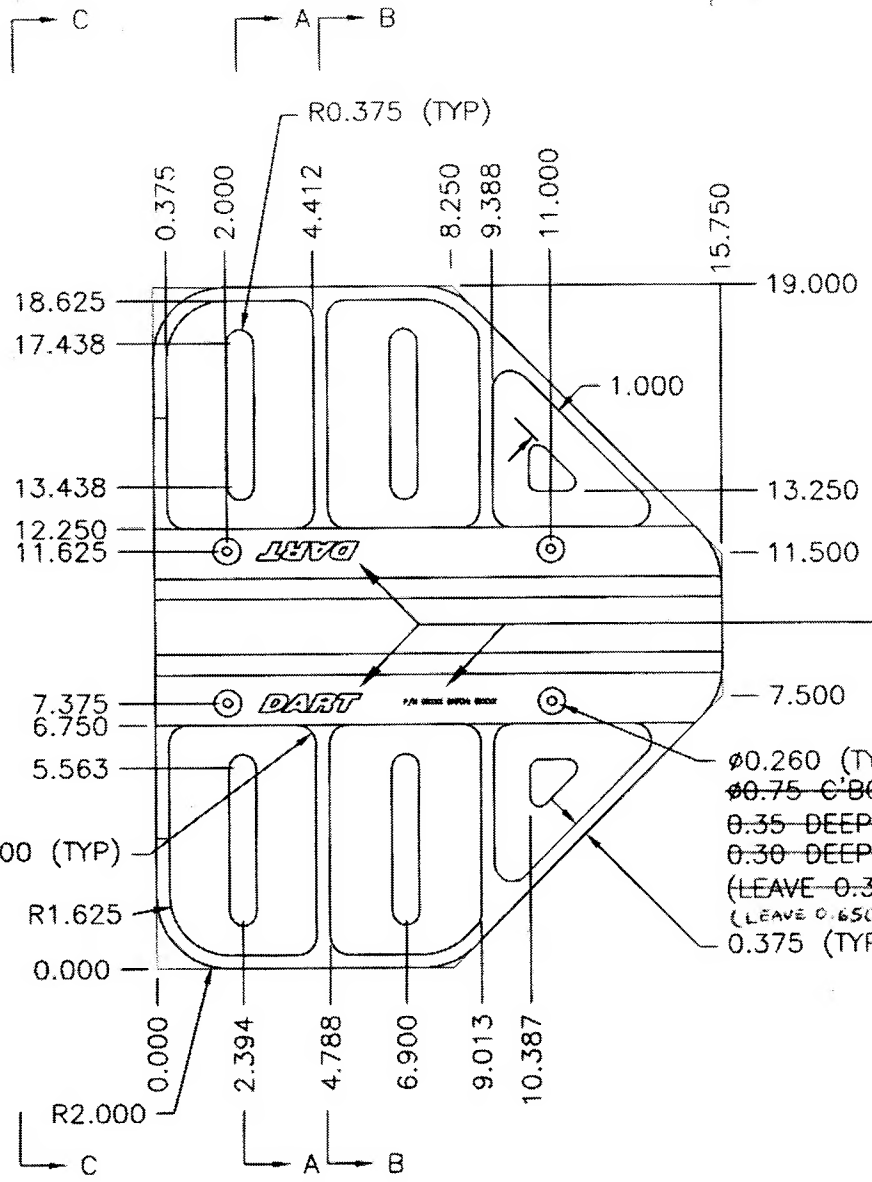
12/06/28

Ø0.260 (TYP) Ø0.93 C'BORE  
Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375 (TYP)



|      |  |
|------|--|
| 9143 |  |
|------|--|

EFFECTIVE DEOS



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

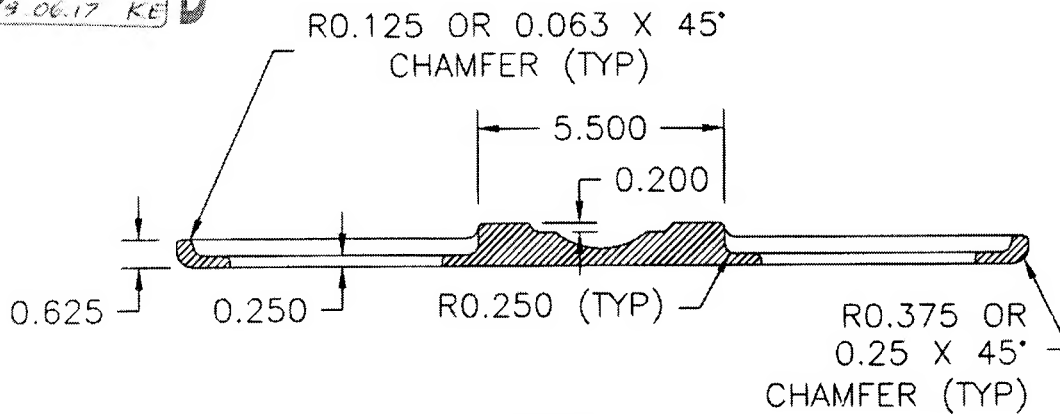
**NOTE:** Date & initial all entries

26342

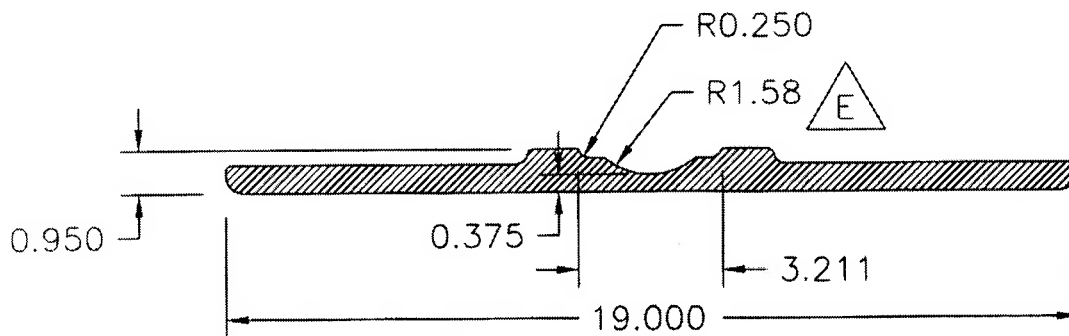


|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>KE          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>MB    | APPROVED<br>[Signature] | DRAWING NO.<br>D2435                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>98.05.19 | TITLE<br>BEARPAW        |   | SCALE<br>1:4           |

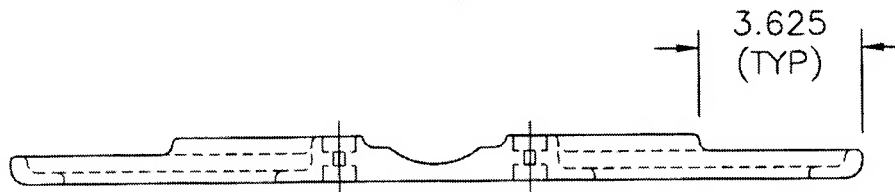
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries